

Date: Wednesday, 2/20/2008 4:23:23 PM
 User: Kim Johnston

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HI-SKI STEP LEG |
| Job Number : 37543 | |
| Estimate Number : 11833 | |
| P.O. Number : | Part Number : D2499 |
| This Issue : 2/20/2008 S.O. No. : | Drawing Number : D2499 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : C |
| Previous Run : 27501 | Material : |
| Written By : | Due Date : 3/10/2008 Qty: 20 Um: Each |
| Checked & Approved By : <u>1808 02 21</u> | |
| Comment : Est. A 00.06.26 Removed P/O for powder coat EC | |
| Est. C Rev C dwg 07-09-25 DD verified by EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B1000X04000 | 6061-T6 Bar 1.0" x 4.0" |
|-----|--------------------|-------------------------|



Comment: Qty.: 1.9906 f(s)/Unit Total : 39.8118 f(s)
 6061-T6 Bar 1.0" x 4.0"
 Material: M6061-T6 aluminium bar 4.00"x 1.00" Thick
 Batch: M106348

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut blanks: 8.500" x 4.000"

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2499
 Deburr

H.A./JML 08/03/17
J-h

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A./JML 08/03/17

08/03/17

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

[Signature]

08/03/17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:23:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-SKI STEP LEG

Job Number: 37543

Part Number: D2499

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1.



(20)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FX 08/03/17

7.0

POWDER COATING

POWDER COATING



(20)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*****mask slot as per dwg*****

M 107005

BR 08-03-18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(x26)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-18

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198

8/3/18

SC (20x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/19

Job Completion



m 2008/3/18 (20)

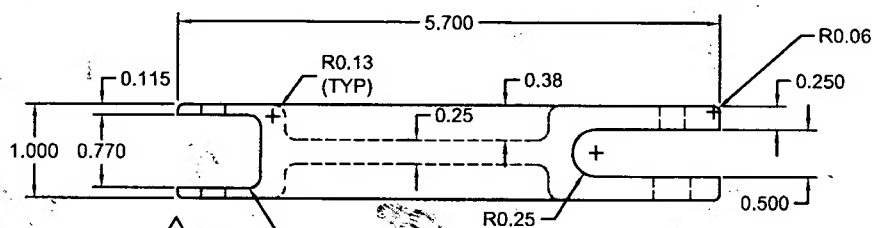
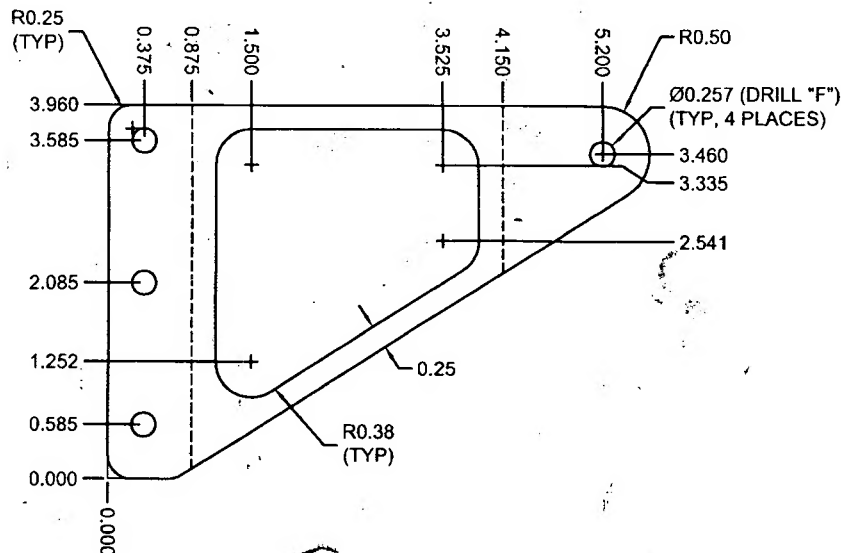
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

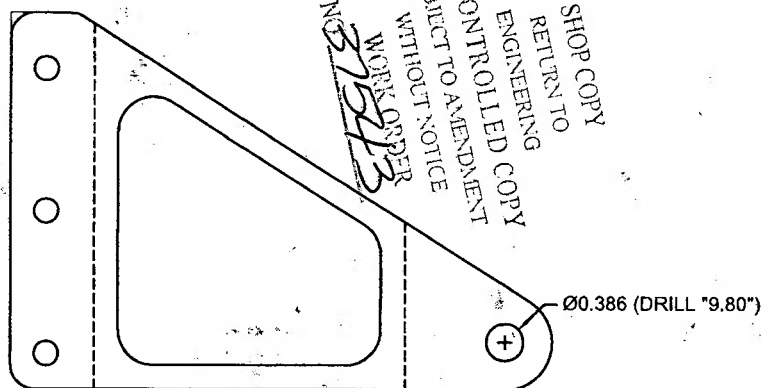
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



△
MASK THIS CHANNEL
PRIOR TO PAINT



RELEASED

07.08.29

D2499 MOUNT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2499" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.65 lbs

| C | - ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE | DC | 07.07.25 |
|------------|---|--|--------------|
| B | CHANGE HOLE DIA TO .386 | KH | 95.12.06 |
| A | NEW ISSUE | BW | 95.11.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | B WILLIAMS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D2499 | SHEET 1 OF 1 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNT | 1:2 |
| DATE | 07.07.25 | COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

| | | |
|------------------------------|--|----------------------------|
| DART AEROSPACE LTD | | Work Order: 37543 |
| Description: MOUNT | | Part Number: D2499 |
| Inspection Dwg: D2499 Rev: C | | Page 1 of 1 Page 1 of 2 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.585 | +/- .010 | 0.583 | ✓ | | | |
| 1.252 | +/- .010 | 1.251 | ✓ | | | |
| 2.085 | +/- .010 | 2.086 | ✓ | | | |
| 3.585 | +/- .010 | 3.585 | ✓ | | | |
| 3.960 | +/- .010 | 3.958 | ✓ | | | |
| 0.375 | +/- .010 | 0.372 | ✓ | | | |
| 0.875 | +/- .010 | 0.875 | ✓ | | | |
| 1.500 | +/- .010 | 1.505 | ✓ | | | |
| 3.525 | +/- .010 | 3.520 | ✓ | | | |
| 4.150 | +/- .010 | 4.150 | ✓ | | | |
| 5.200 | +/- .010 | 5.1985 | ✓ | | | |
| 3.460 | +/- .010 | 3.468 | ✓ | | | |
| 3.335 | +/- .010 | 3.335 | ✓ | | | |
| 2.541 | +/- .010 | 2.541 | ✓ | | | |
| 0.25 | +/- .030 | 0.2455 | ✓ | | | |
| 5.700 | +/- .010 | 5.697 | ✓ | | | |
| 0.115 | +/- .010 | 0.112 | ✓ | | | |
| 0.770 | +/- .010 | 0.769 | ✓ | | | |
| 1.000 | +/- .010 | 0.991 | ✓ | | | |
| 0.25 | +/- .030 | 0.249 | ✓ | | | |
| 0.38 | +/- .030 | 0.378 | ✓ | | | |
| 0.250 | +/- .010 | 0.244 | ✓ | | | |
| 0.500 | +/- .010 | 0.502 | ✓ | | | |

| |
|-------------------------------|
| Measured by: KA / [Signature] |
| Date: 08/03/17 |

| |
|-------------------------|
| Audited by: [Signature] |
| Date: 08.03.17 |

| |
|---------------------|
| Prototype Approval: |
| Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/RF | |

Page 2 of 2

☒ **First Article** ☐ **Prototype**

| | | | | | |
|--------------|------------------|-------------|--------------------|---------------------|--|
| Measured by: | H.A / <i>amr</i> | Audited by: | <i>[Signature]</i> | Prototype Approval: | |
| Date: | 08/03/17 | Date: | 08.03.17 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/RF | |